

Work Order ID 159325

Friday, April 07, 2017 12:50:05 PM

159325

Page 1

Item ID: D022-661-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R22 Bearpaws
 Start Date: 4/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/21/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan: DAS 21 Date: APR 07 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3076	Rev A1								

100 ***100*** DOCUMENT CONTROL MAY 31 2017 DAS 6 9-89 0.00
 DC Memo Photocopy bluefile & type labels per PPPd022-661-011 CHG002 DAS 28 9-89 JUN 12 2017

110 ***110*** QC4- 100% Inspect kits for completeness 0.00
 QC Memo 0.00 Pick Kit QC.4. JUN 09 2017 DAS 6 9-89 DAS 27 9-89
 Quality Control DAS 28 9-89 JUN 12 2017

120 ***120*** Packaging 0.00
 Packaging Memo 0.00 Identify and pack for shipping as per PPP D022-661-011
 Packaging Location: E9014 DAS 28 9-89 JUN 12 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00					0.00		
130							21		
QC	Memo	0.00					9-89		
Quality Control									

JUN 12 2017 JUN 12 2017

DAS
21
9-89

JUN 12 2017

Picklist Print

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Work Order ID: 159325

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Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 4/10/2017

Required Date: 4/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C04.02.19Added tolerance and ref to DSK086-12 to Step 3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B *D2182B* 028 Rubber Cushion - Black (\$Per Foot)		Manufactured	No			110	f	36.8450	0.93 **	0.93		JUN 09 2017	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST411				36.845					
				135093				36.845					
D2274 *D2274* Radius Block		Manufactured	No			110	Each	586.0000	8 **	8		JUN 09 2017	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				12					
				86855				12					
				ST004				414					
				155086				414					
				ST012a				160					
				157272				160					
D2529 *D2529* Washer		Manufactured	No			110	Each	270.0000	8 **	8		JUN 09 2017	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST008				270					
				155073				170					
				157443				100					

Picklist Print

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Work Order ID: 159325

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Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 4/10/2017

Required Date: 4/21/2017

Start Qty: 1.00

Required Qty: 1.00

D2870

Manufactured No

110 Each

120.0000

2 2

D2870

Clamp

**

JUN 0 9 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

Mezz 31

120

16244

27

26941

93

2

D2871

Manufactured No

110 Each

148.0000

2 2

D2871

Clamp

**

JUN 0 9 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

Mezz

148

16245

44

16838

104

2

D3076-1

Manufactured No

110 Each

2.0000

2 2

D3076-1

R22 Bearpaw

**

JUN 0 9 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST446A

2

140143

2

2

DAS
28
9-89

Picklist Print

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Work Order ID: 159325

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Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 4/10/2017

Required Date: 4/21/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

110

Each

217.0000

8

8

AN4-13A

Bolt

**

DAS 6 JUN 09 2017 9-89

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

76

m134634

19

m135470

57

over003

100

m137166

100

ST344

21

m136787

1

m137073

20

137344

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

8

8

AN960JD416

Washer

**

DAS 6 JUN 09 2017 9-89

DAS 27 9-89

DAS 28 9-89

MS21042L4

Purchased

No

110

Each

1,235.000

8

8

MS21042L4

Nut

**

DAS 6 JUN 09 2017 9-89

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

154

m135058

154

OVER007

500

m137166

500

ST303

571

m136450

69

m136838

2

m136986

500

137371

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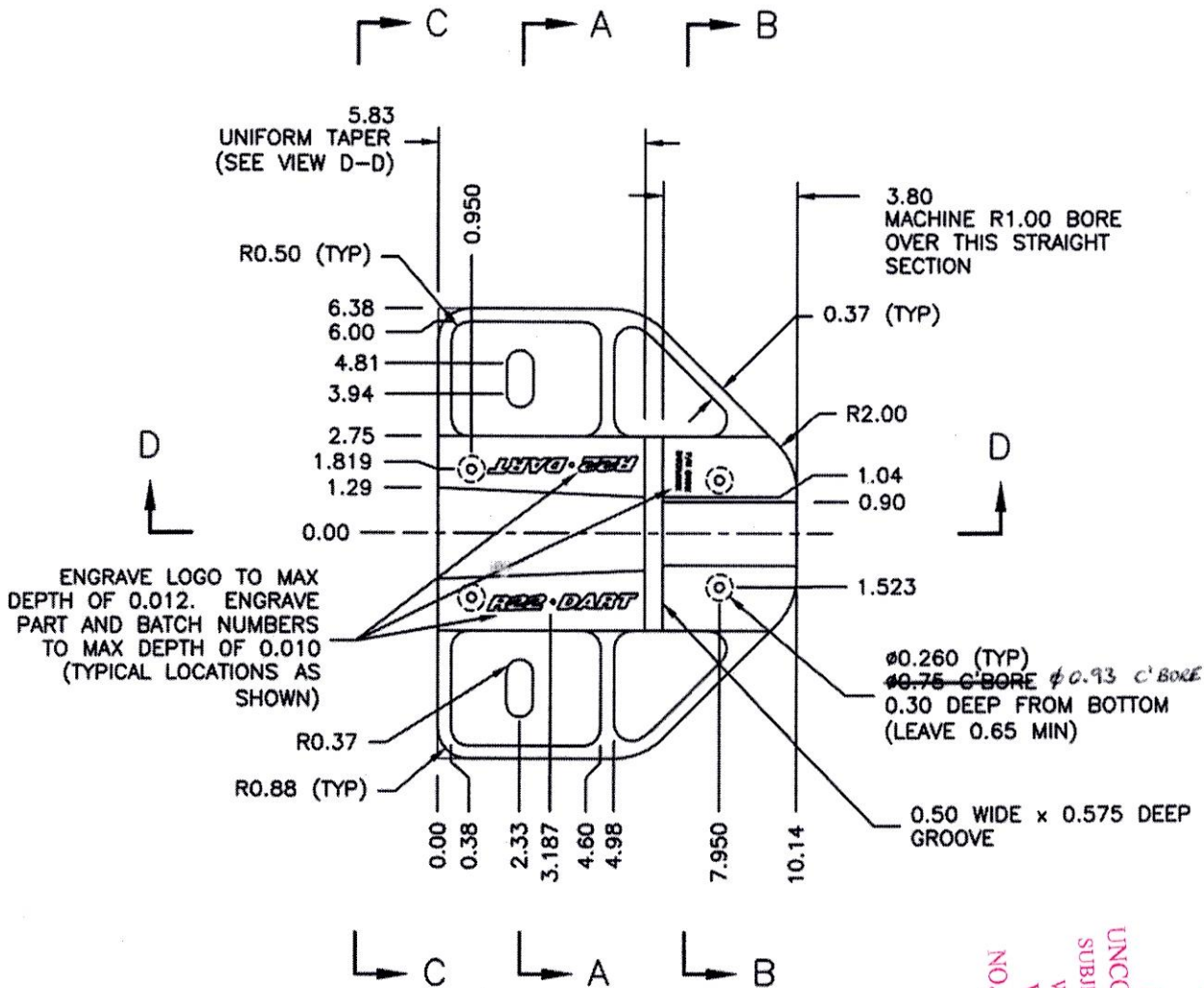
Shop Packet Print

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DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 1 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:5
A	02.01.08	NEW ISSUE	
AI	03.01.06	φ 0.93 WAS φ 0.75	

RELEASED
02.01.10



D3076-1 BEARPAW (FLAT PATTERN)

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

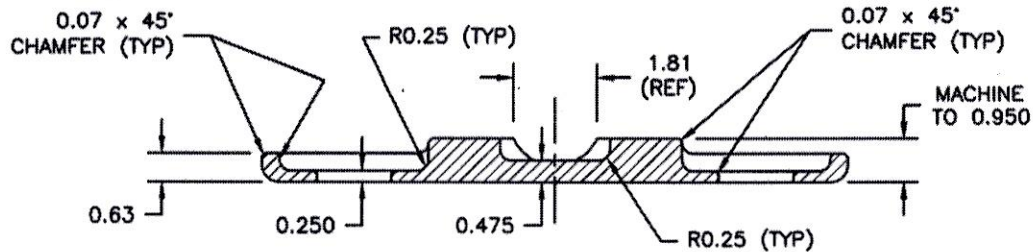
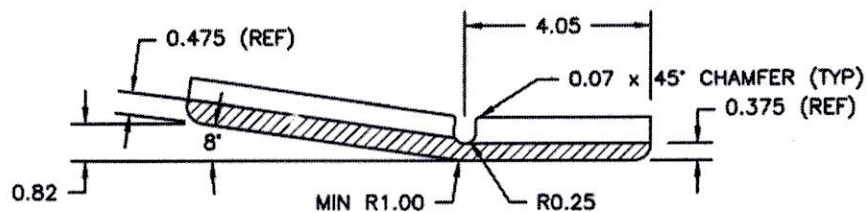
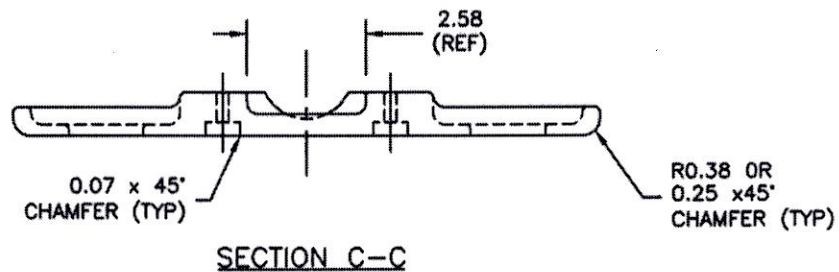
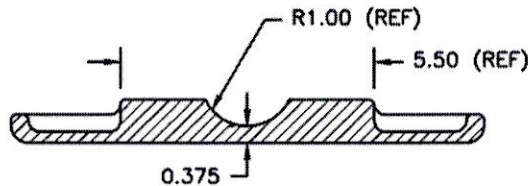
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159325
170404

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DART

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 2 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:4

**RELEASED**
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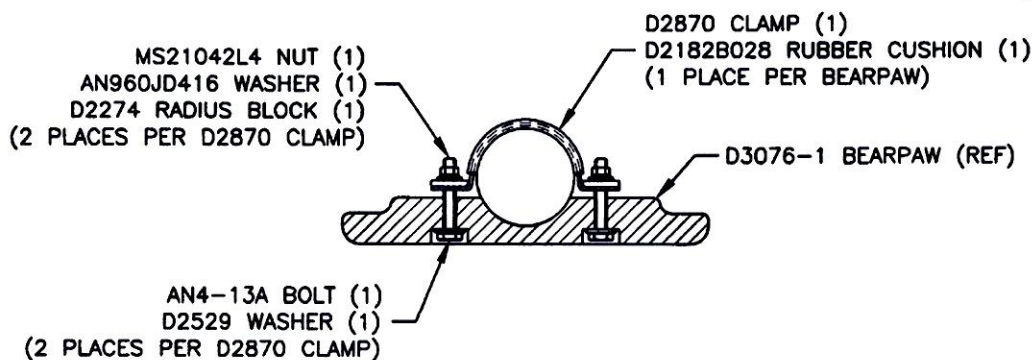


Figure 3 – Bearpaw Installation. Forward Clamp (section view)

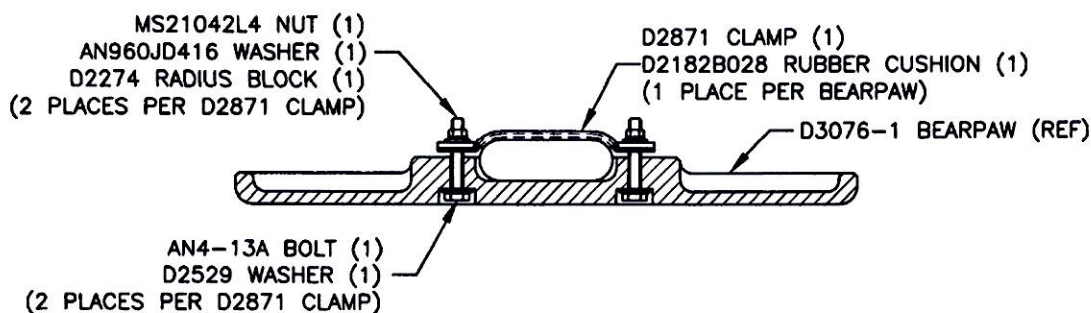


Figure 4 – Bearpaw Installation. Aft Clamp (section view)

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D022-661-011 Bearpaw Installation on model R22 aircraft	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 lb-k 0.0 m-k	121.1 in 3.08 m	557.1 in-lb 6.47 m-k

5. PARTS LIST

Qty	Part Number	Description
X	D022-661-011	BEARPAW INSTALLATION
4	D2182B028	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2870	Clamp
2	D2871	Clamp
2	D3076-1	Bearpaw
8	AN4-13A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R22 Bearpaws

Start Date: 4/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/21/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED

Approvals:

Process Plan:

Date: APR 17 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Reject
Insp.
Stamp

Draw Nbr

Revision Nbr

APR 20 2017

D3076

Rev A1

100

100

DC

DOCUMENT CONTROL

MAY 31 2017

0.00

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPd022-661-011 CHG002

CB

JUN 01 2017

110

110

QC

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

120

120

Packaging

Packaging

Memo

Identify and pack for shipping as

Location: _____

Packaging